

Work Order ID 129428

129428

Page 1

Item ID: D2282-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Saddle Assembly

Stop

NS2

Start Date: 2/09/15 Start Qty: 15.00

15

Cust Item ID:

Required Date: 2/27/15 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2282

Rev E

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per D2282-043 Saddle Assembly

A/RER316L SS

Filling Rod 123/23

Dwg Rev: _____

15

15-03-16

JOL

110

0.00

110

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Grind weld with rough pad and brown pad, take all welding marks out and deburr holes***DO NOT TAKE RED AND BLUE PAD TO BUFF PART***

15

15-03-17

JOL

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

DAS
24
9-89

MAR 19 2015

1 29428

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 2/09/15 **Start Qty:** 15.00 ***15***

Cust Item ID:

Required Date: 2/27/15 **Req'd Qty:** 15.00 ***15***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

Work Order ID 129428

February-09-15 10:58:25 AM

129428

Page 3

Item ID: D2282-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle Assembly
Start Date: 2/09/15 Start Qty: 15.00 ***15*** Cust Item ID:
Required Date: 2/27/15 Req'd Qty: 15.00 ***15*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

ML5 1503-23

MF

15-3-23

Picklist Print

February-09-15 10:58:24 AM

Page 1

Work Order ID: 129428

129428

Parent Item: D2282-043

D2282-043

Parent Item Name: Saddle Assembly

Start Date: 2/09/15

Required Date: 2/27/15

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2281		Manufactured	No			100	Each	0.0000	1	15			
D2281					129701				**	15			15-03-17
Jack Saddle													JL
D2282-7		Manufactured	No			100	Each	22.0000	2	30			
D2282-7									**				15-03-17
Tube													JL

Location

WA002

111550

Loc Qty

22

22

Loc Code

22

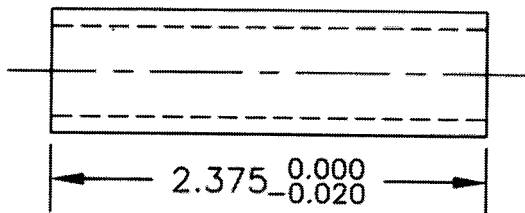
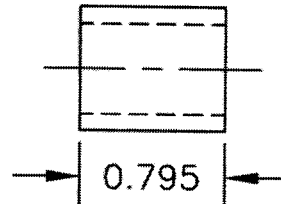
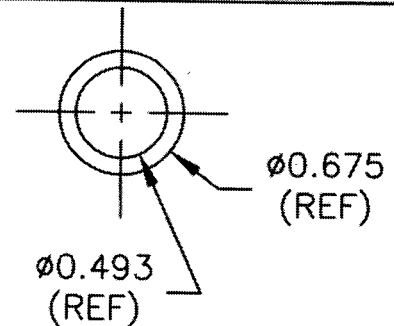
B129935 x 8

DART

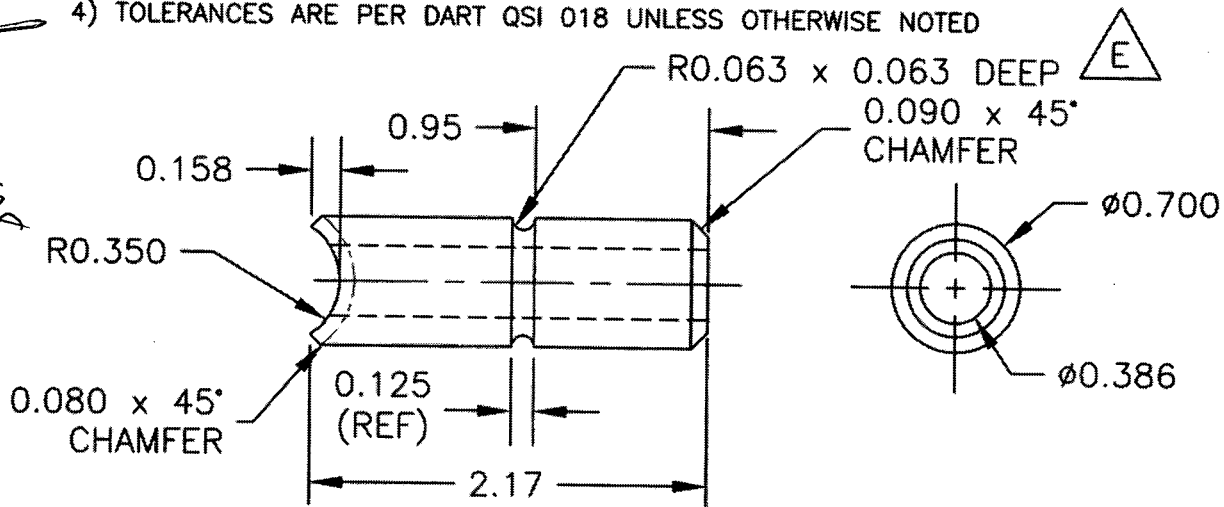
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

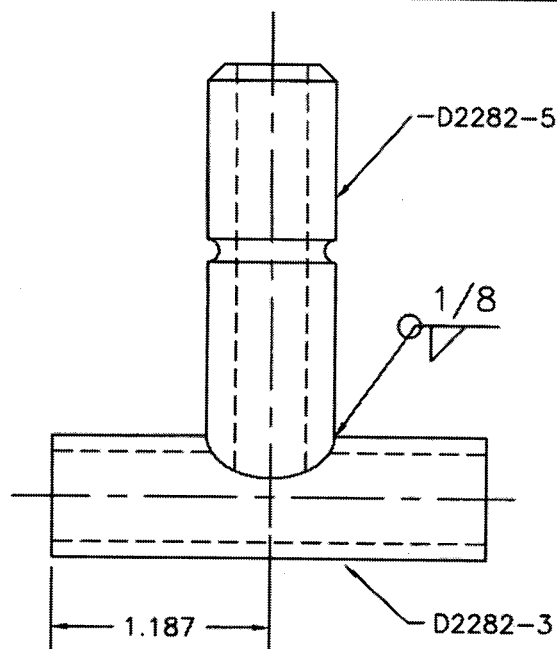


Copyright © 1994 by DART AEROSPACE LTD

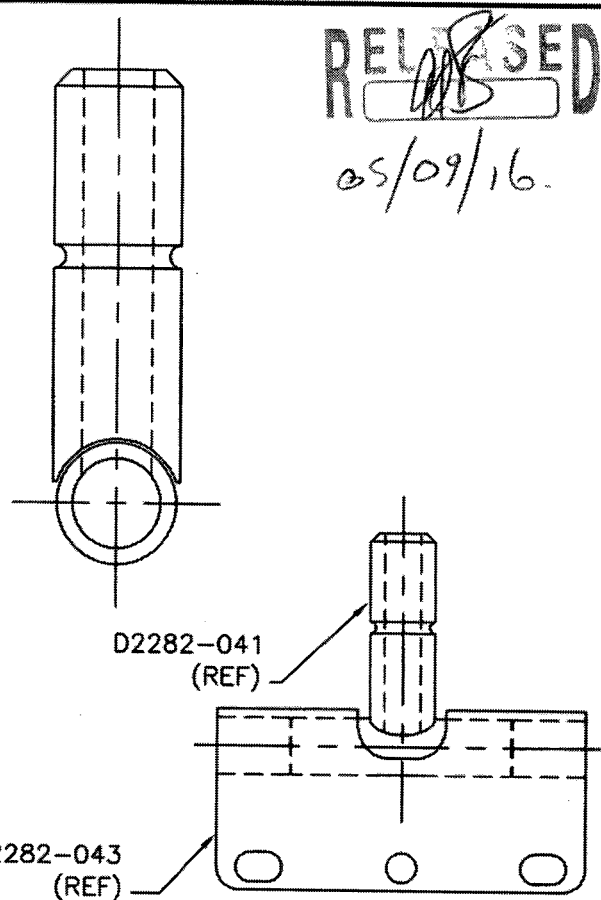
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



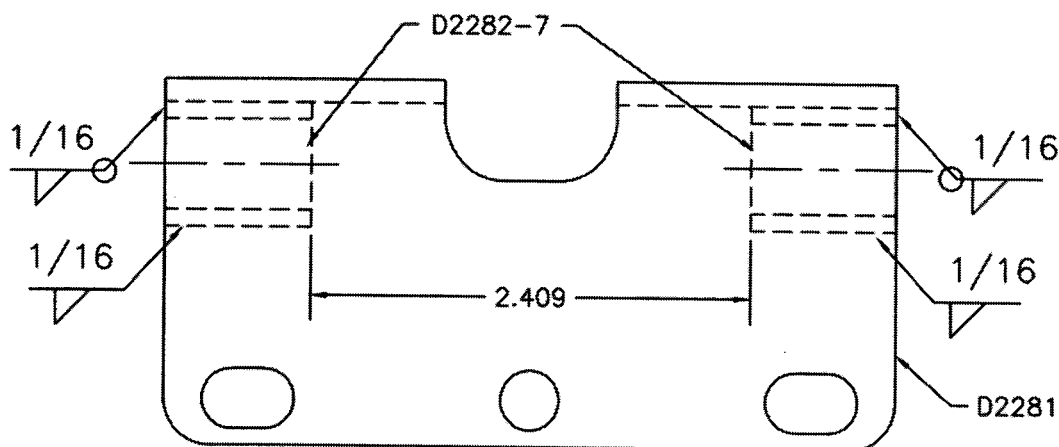
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.